Work Order ID 119897

May-29-14 9:22:27 AM

119897

Item ID: D3117-3-0980 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Seal98"

Start Date: 5/29/14 **Start Qty:** 4.00 *4*

Required Date: 5/29/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3117	Rev C U/R								
100		0.00							
100	Small Fab								
Packaging	**Memo**	0.00							
Packaging	PULL FROM STK: D3237-3 B 105247 CUT 4 PIECES TO 98"								
110	QC5- Inspect part completeness to step on W/O	0.00				4			
110									
QC	**Memo**	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: _____	0.00							
120									
Packaging	**Memo**	0.00							
Packaging	RE-IDENTIFY USING NEW P/N AND NEW B/N								

Acceptable based on previous sign off 4/14/5/29

SHIP 14/5/29

PO 116745 5/29 4

4/14/5/29 4

Work Order ID 119897

May-29-14 9:22:27 AM

119897

Item ID: D3117-3-0980 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Seal98"

Start Date: 5/29/14 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 5/29/14 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130						MW	14-05-29		
QC	**Memo**	0.00							
Quality Control									

MF 14-5-29

Picklist Print

May-29-14 9:22:26 AM

Work Order ID: 119897

119897

Parent Item: D3117-3-0980

D3117-3-0980

Parent Item Name: Seal98"

Start Date: 5/29/14 **Required Date:** 5/29/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A 10.11.02 as per revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3237-3		Manufactured	No				f	128.2000		33			
D3237-3 Seal Filler(Price Per Sq Ft)									**				

Location	Loc Qty	Loc Code
ST404	128.2	
105247	128.2	

4/C 4/15/29

105247

Linda Lacelle

From: Shirley Hay
Sent: May-28-14 4:25 PM
To: Linda Lacelle; Chris Provencal
Subject: RE: PO pending

Order is coming....thanks Shirley

From: Diana Hagen
Sent: Wednesday, May 28, 2014 10:32 AM
To: Shirley Hay
Subject: FW: PO pending

11897

FYI...

From: Chris Provencal
Sent: Wednesday, May 28, 2014 10:26 AM
To: Linda Lacelle; Diana Hagen
Cc: Melanie Fauteux
Subject: RE: PO pending

We want to use D3237-3-0980, but re-identify it as D3117-3-0980. Linda, if you issue the w/o for D3117-3-980, I'll sign it off as I did last time.

-Chris

From: Linda Lacelle
Sent: Wednesday, May 28, 2014 7:15 AM
To: Diana Hagen; Chris Provencal
Cc: Melanie Fauteux
Subject: RE: PO pending

Pls see below

From: Diana Hagen
Sent: May-27-14 4:03 PM
To: Linda Lacelle
Cc: Melanie Fauteux
Subject: PO pending

Howdy,

Please advise lead time for the following:

D3117-1-0980 30' so Qty 4? - stk
D3117-3-0980 30' so Qty 4? – we are to use the D3237-3-0980 – stk, correct Chris??

Thanks,

DIANA HAGEN
Account Manager
DART AEROSPACE
T 1 613 632-3336 > 269
M 1 613 677-2174
1 800 556- 4166
www.dartaerospace.com

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: [signature] Date: 14/04/09

QA Closed: [signature] Date: 14/4/14

Work Order: 115360

Part No. D3117-3-098

NCR No. 14-3690

DISPOSITION

Rework	X
Scrap	
Use-as-is	
Work Order Update	

AGAINST DEPARTMENT/PROCESS

Skid-tube		Crosstube		Water Jet		Engineering	
Machining		Small Fab		Prod. Eng. Coor.		Quality	
Thermoforming		Finishing		Rec/Store/Packaging		Other	
Large Fab		Composite		Supplier			

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data		14/3/27	100	1	LOAD TEST DONE PER ADR (14/3/26) SHOWS THAT D3237-3 IS FUNCTIONALLY EQUIVALENT TO D3117-3. Ref attached ADR	DAS 12 9-89 14/3/27	Accepted to re-identify D3237-3 as D3117-3	DAS 12 9-89 14/3/27	DAS 27 9-89 14/3/27	DAS 27 9-89 14/3/27
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- [] Bending
- [] Centre Not Concentric to O/S
- [] Cracks
- [] Crushed/Crimped
- [] Cuffs
- [] Heat Treat
- [] Inspection Strip in Tube
- [] Ripples in Bend
- [] Torque Waves in Extrusion
- [] Turning Sequence
- [] Wave/Twist in Tube

General

- [] Bend
- [] BOM/Route
- [] Broken/Damaged
- [] Burrs
- [] Contamination
- [] Countersink
- [] Cut Too Short
- [] Drill Holes
- [] Drawing
- [] Finish
- [] Folio
- [] Grain
- [] Hardware
- [] Inspection Incomplete
- [] Instructions Incomplete/Unclear
- [] Maintenance
- [] Mislabeled
- [] Misread
- [] Offset
- [] Out of Calibration
- [] Out of Sequence
- [] Outside Dimensions
- [] Ovalized
- [] Over/Under tolerance
- [] Part Incorrect
- [] Part Lost/Missing
- [] Part Moved
- [] Positioned Wrong
- [] Power Loss/Surge
- [] Pressure/Forced
- [] Temperature/Cure
- [] Weld
- [] Wrong Stock Pulled
- [] Other

DART AEROSPACE LTD.

AMENDMENT DESIGN REVIEW (ADR)

Part/Installation No.: D3117-1/-3 Rev: D Design Review No.: _____ Date: 14.03.26

Project Number: ENG5105MAR Project Description/Title: SEAL RETAINER AND SEAL FILLER (D412-694)

Eng. Project Manager: M. BELLAVANCE

Persons Present	Title	Initial
M. PETSCHE	Design Manager	
M. BELLAVANCE	Engineering Project Manager	
D. SHEPHERD	Chief Engineer (DE #02)	
	Manufacturing Manager	
P. SMITH	Quality Manager	
C. PROVENCAL	Mechanical Designer	
D. STOW		

Comments

VIP Rubber advised that they were required to come up with new tooling for manufacturing of D3117-1/-3 Seal Retainer/Filler. Proofing of samples is required by DART in accordance with TP-D412-694-2 Rev. A.

During the testing procedures dated 14.03.13, the D3117-1-0980/-3-0980 Seals B114784/B114785 passed the Phase 1 Limit Load but failed the Phase 1 Ultimate Load.

Due to the urgency of supplying replacement parts to a customer, DART conducted the following test on 14.03.24: D3117-1-0980 B84497 was installed with window onto Spacedoor using D3237-3-0980 B105247. This setup passed all TP-D412-694-2 Rev. A window test phases. The window survived the Limit Test (103.5#) without permanent deformation and the Ultimate Load test (160.5#) without failure. The window released with a load of 49.5# when applied locally at bottom corner.

Other than some dimensional changes reflecting VIP Rubber tooling update, revision of D3117 to Rev. D will also include that D3237-1 can be used as an acceptable substitute for D3117-3.

These changes affect compliance to FAR 29.305/307/809 for wich DE#02 is delegated. Therefore, approval by DE#02 is acceptable.

Key Tasks (Check or N/A)	Check	Responsible	Completion Date
Review Outstanding TSR/NCR/CAR/PAR	Y	MB	
Fill out Criteria/Constraints Form – Inputs	N/A		
Fill out Project Evaluation Form	N/A		
D-Part creation/revision	Y	MB	
Get Manufacturing Input	N/A		
First Article Inspection	Y	ED	
Fit and Function Test	Y	MB/DSTOW	14.03.26
Structural Test	Y	DSTOW/CP	14/3/26
Reports (Compliance, Loads, Stress, Conformity, DSI)	N/A		
Check Drawings against all QSIs	Y	MB	
Review Criteria/Constraints Form	N/A		
Revision to existing approval	N/A		
Close Amendment Project	Y	MB	

Conclusion:

Revise drawing D3117 to Rev. D and release on ECN: